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D2282-5

Job Sheet 182552



Part No: D2282-5

Job Qty: 100 ea

Part Name: Tube



Part Weight: 0 lbs

Job Created: 8/28/18

Due Date: 9/20/18

Type: SOLD

Status: Scheduled

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Priority: Medium

Note: DWG REV E IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPPRev:B Now on Doosan Lathe 08-06-05 JLM
Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	100 Ea	9/20/18	9/20/18	0.00	0.00	Start Up Machining		
100	Doosan	100 pcs	9/20/18	9/20/18	0.03	15.54	Doosan		
120	QC	100 pcs	9/20/18	9/20/18	0.00	0.00	QC8		
130	Packaging	100 pcs	9/20/18	9/20/18	0.00	0.00	Packaging3		
140	QC21-SA	100 Ea	9/20/18	9/20/18	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Dwg D2282 and Folio FA189
Descriptions: 130 - *****STOCK IN LARGE FAB*****

DAS
21
9-25
SEP 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304RO.750	304 SS Roundbar .750	18.0060 ft (.18006 ea)	90-Start up Operation	5033397

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304RO.750	18	18	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Handle Tube	2.170Inches ± 0.030	2.200 2.140	2.169	
2	Handle Tube	0.063Inches ± 0.010	0.073 0.053	0.063 Radius	
3	Handle Tube	0.063Inches ± 0.010	0.073 0.053	R.062	
4	Handle Tube	0.125Inches ± 0.010	0.135 0.115	.127	
5	Handle Tube	0.090Inches ± 0.010	0.100 0.080	.091	
6	Handle Tube	45.000Degrees ± 0.000	45.000 45.000	45 Angle	
7	Handle Tube	0.350Inches	0.360	R.035 Radius	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

			+ 0.010	0.350	
			- 0.000		
8	Handle Tube	0.158Inches	± 0.010	0.168 0.148	.159
9	Handle Tube	0.386Inches	+ 0.005 - 0.000	0.391 0.386	.386 Diameter
10	Handle Tube	0.700Inches	± 0.010	0.710 0.690	.700 Diameter

Plex 8/28/18 10:09 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____
Part No. _____
NCR No. _____

Date : _____ Step #: _____

Description Work Order I

		Engineering ☐	Quality ☐	Other ☐
		MRB (QSI042) Approval		
		Completed By		
		Lead hand / Supervisor Approval Verification		
		QC / QA Coordinator Approval		

Part: D2282-5
 Job No: 182552
 Serial No/Batch: S113672
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's
 Date: 09/26/18

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Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						